

Work Order ID 108205

November-13-13 1:23:17 PM

Reprint

108205

Page 1

Item ID: D4543-6

Accept

N900040100

Setup Start *NS1*

Revision ID:

D 4543-6
B 108205

Stop *NS2*

Item Name: Retainer, Outer, RH

Start Date: 10/08/13 Start Qty: 22.00

22

Cust Item ID:

Required Date: 10/08/13 Req'd Qty: 22.00

22

Customer:

Reference:

Approvals:

Process Plan: *U*

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4543

B

100

0.00

100

Waterjet

FLOW CNC Waterjet

Memo

1- Cut D4543-5F as per dwg

Prog rev: *B*

Dwg rev: *B*

2- Deburr

0.00

22 0 Ae
13.11.01

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

22 0 Ae
13.11.01

Work Order ID 108205

108205

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Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Retainer, Outer, RH

Stop *NS2*

Start Date: 10/08/13 Start Qty: 22.00

22

Cust Item ID:

Required Date: 10/08/13 Req'd Qty: 22.00

22

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

130

130

Small Fab

Memo

0.00

Small Fab

FORM ON BEAD ROLLER (DT9787)

***MAKE ONE AND ENSURE IT'S MADE AS PER DWG BEFORE
MAKING QTY REQUIRED ON W/O***

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

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Item ID: D4543-6

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Retainer, Outer, RH

Start Date: 10/08/13 Start Qty: 22.00

22

Cust Item ID:

Required Date: 10/08/13 Req'd Qty: 22.00

22

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Chemical Conversion Coat per QS1005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

22 26 13-11-13

160

QC7-Inspect Chemical Conversion Coat

0.00

160

QC

Memo

0.00

Quality Control

DAS
27
9-89

B 11 B

22

170

Identify as per dwg & Stock Location: ST529

0.00

170

Packaging

Memo

0.00

Packaging

DAS
33
9-89

13-11-13

22

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Item ID: D4543-6

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Retainer, Outer, RH

Start Date: 10/08/13 Start Qty: 22.00

22

Cust Item ID:

Required Date: 10/08/13 Req'd Qty: 22.00

22

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

13/11/14

13-11-14

Picklist Print

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Page 1

Work Order ID: 108205

Parent Item: D4543-6

Parent Item Name: Retainer, Outer, RH

Start Date: 10/08/13

Required Date: 10/08/13

Start Qty: 22.00

Required Qty: 22.00

Comments: IPP REV:A 13.04.23 as per dwg revB DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032 6061-T6 Sheet 0.032"		Purchased	No			100	sf	573.9160	2	46.315790			

Location

Loc Qty

Loc Code

MAT021

573.916

123483

256.15

m125822

48.1

m126115

60.356

m126309

55.31

m127272

154

LOT TRACKING !!

Parent Item ID	Reason	Lot Qty	Lot Nbr	Lot Trans Date
M6061T6S.032	108205	-20	m127272	11/01/13 8:40:34 AM

Work Order Summary

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Criteria : Work Order ID: 108205 Item ID: D4543-6 Product Family SMALL FAB

Work Order Start Dates 10/08/13 to 10/08/13 11:59:59 PM Work Order Required Dates 10/08/13 to 10/08/13 11:59:59 PM

All References

Work Order Status Released

Work Order ID	108205	Required Qty	22.0000	Status Code	Released
Item ID	D4543-6	Accepted Qty	0.0000	Scrap Qty	0.0000
Item Name	Retainer, Outer, RH				
Current Acct Value	\$12.525				

Start Date	10/08/13	Required Date	10/08/13	Completed Date	
Standard	** Actual **	** Acct. Value **	** Variance **	** Variance % **	
Direct Costs	Total	Each	Each	Each	Each
Material	\$35.564	\$0.000	\$3.838	\$3.838	100.00%
Labor	\$49.878	\$0.000	\$7.919	\$7.919	100.00%
Outplant	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Variable Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Fixed Burden	\$111.169	\$0.000	\$18.152	\$18.152	100.00%
Material Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
** Total **	\$196.611	\$0.000	\$29.909	\$29.909	

Item ID/Item Name	Required Qty	Issue Code	Issue Date	Issued Qty	Cost Amount
M6061T6S.032					
6061-T6 Sheet 0.032"	46.3158		11/01/13	20.0000	\$35.564
				Total Matl Amts:	\$35.564

Work Center HandFinish

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
GIRA02												
	11/12/13											
150			0.00	0.00	1.91	1.91	1.00	\$0.000	\$36.303	\$76.717	\$0.000	\$113.02
Total:			0.00	0.00	1.91	1.91	1.00	\$0.000	\$36.303	\$76.717	\$0.000	\$113.02

Work Center Small Fab

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
FRAN01												
	11/04/13											
130			0.00	0.00	0.41	0.41	1.00	\$0.000	\$8.149	\$20.682	\$0.000	\$28.83
Total:			0.00	0.00	0.41	0.41	1.00	\$0.000	\$8.149	\$20.682	\$0.000	\$28.83

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Work Order Summary

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Work Center Waterjet

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
MACL01												
	11/01/13											
100			0.00	0.00	0.27	0.27	1.00	\$0.000	\$5.426	\$13.771	\$0.000	\$19.19
Total:			0.00	0.00	0.27	0.27	1.00	\$0.000	\$5.426	\$13.771	\$0.000	\$19.19

8 7 6 5 4 3 2 1

D

D

C

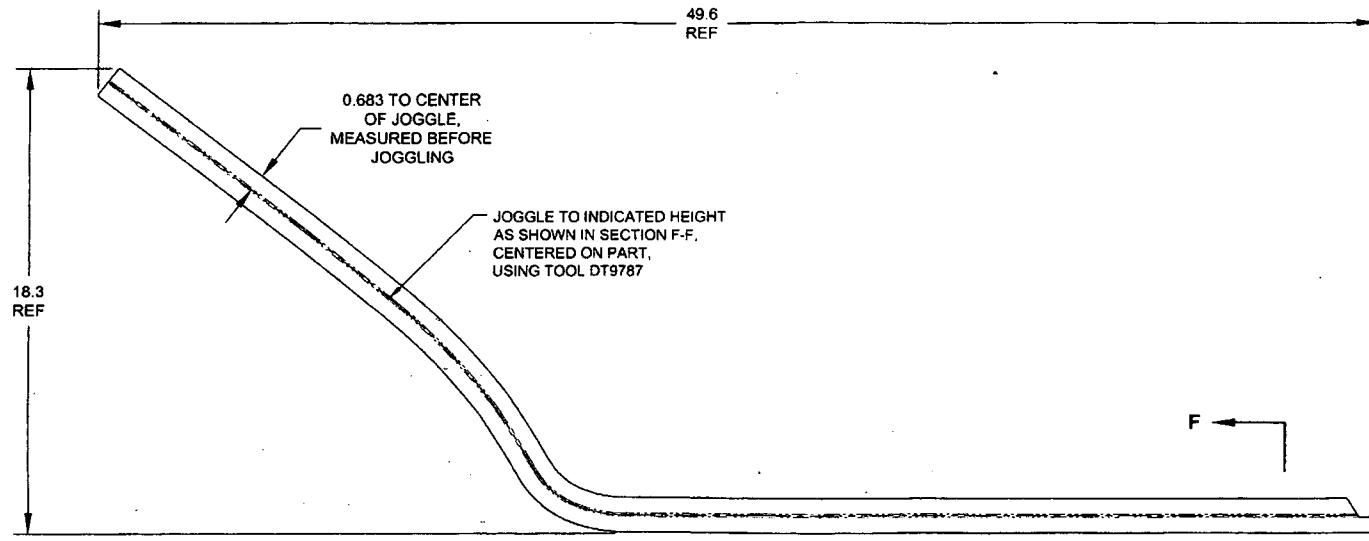
C

B

B

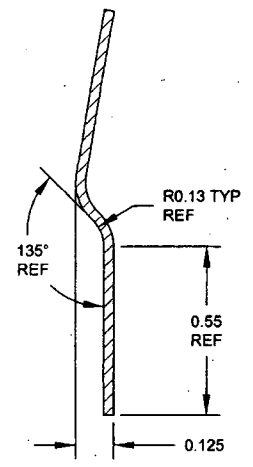
A

A



0.683 TO CENTER
OF JOGGLE,
MEASURED BEFORE
JOGGLING

JOGGLE TO INDICATED HEIGHT
AS SHOWN IN SECTION F-F,
CENTERED ON PART,
USING TOOL DT9787



SECTION F-F
JOGGLE DETAIL
SCALE 12X

D4543-6 RETAINER, RH OUTER
(SIDE/TOP)



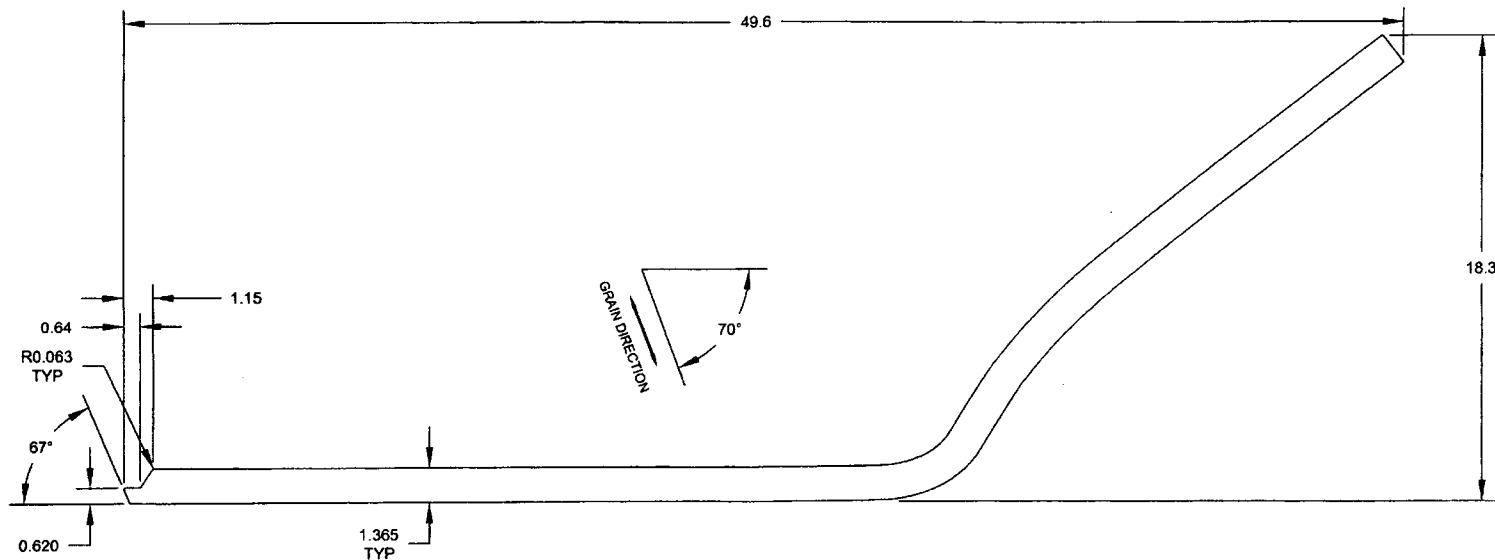
RELEASED
2013-04-22

- NOTES:**
- 1) MATERIAL: MAKE FROM D4543-5F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1
 - 7) WEIGHT: 0.24 lbs

w/o
108205

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4543	SHEET 8 OF 9
APPROVED		TITLE	SCALE
DE APPR.		RETAINER, OUTER	NTS
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8 7 6 5 4 3 2 1



D4543-5F FLAT PATTERN



RELEASED
2013-04-22

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.24 lbs
- 8) PROFILE PER DRAWING FILE "D4543-5F-REV-B.DXF"

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4543	SHEET 9 OF 9
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